

which has been used is intended to be in the nature of words of description rather than of limitation.

[0068] Obviously, many modifications and variations of the present invention are possible in light of the above teachings. It is, therefore, to be understood that within the scope of the appended claims, wherein reference numerals are merely for convenience and are not to be in any way limiting, the invention may be practiced otherwise than as specifically described.

What is claimed is:

1. A baked and freezer stable filled waffle comprising:

an outer casing material formed from a batter comprising a homogeneous mixture of from 30 to 65 percent by weight water, from 25 to 70 percent by weight of a flour, from 0.05 to 2.5 percent by weight of a bicarbonate and from 0.04 to 2 percent by weight of a leavening acid;

said outer casing material surrounding a filling material having a positive water content of up to 40 percent by weight and said water content in said filling material being less than said percent by weight water in said outer casing material; and

said outer casing material having a water activity level of from 0.9 to 0.99 and said filling material having a water activity level of less than or equal to 0.95 with said water activity level of said filling material being less than said water activity level of said outer casing material.

2. A filled waffle as recited in claim 1, wherein said filling material has a water activity level of from 0.7 to 0.95.

3. A filled waffle as recited in claim 1, wherein said filling material has a water activity level of from 0.80 to 0.90.

4. A filled waffle as recited in claim 1, wherein said filling material comprises at least one of a fruit based filling, a cream cheese based filling, a sweet flavored filling, or mixtures of these.

5. A filled waffle as recited in claim 1, wherein said filling material comprises a savory filling.

6. A filled waffle as recited in claim 5, wherein said filling material comprises at least one of cheese, tomato, tomato and herbs, tomato sauce, vegetables, cheese and vegetable combinations, a cheese, tomato, tomato and herbs, tomato sauce, vegetables, cheese and vegetable combinations, bacon, ham, pork sausage, beef sausage, meat analogs, or mixtures thereof.

7. A filled waffle as recited in claim 1, wherein the ratio of outer casing material to filling material ranges from 2:1 to 8:1.

8. A filled waffle as recited in claim 1, wherein said flour of said outer casing material comprises at least one of all-purpose flour, hard wheat flour, soft wheat flour, whole wheat flour, corn flour, oat flour, rice flour, barley flour, or mixtures thereof.

9. A filled waffle as recited in claim 1, wherein said bicarbonate of said outer casing comprises at least one of ammonium bicarbonate, potassium bicarbonate, sodium bicarbonate, or mixtures thereof.

10. A filled waffle as recited in claim 1, wherein said leavening acid of said outer casing comprises at least one of fumaric acid, adipic acid, acetic acid, tartaric acid, monocalcium phosphate monohydrate, anhydrous monocalcium phosphate, anhydrous dicalcium phosphate, dicalcium phos-

phate dihydrate, sodium acid pyrophosphate, sodium aluminum phosphate, monoaluminum phosphate, dialuminum phosphate, monoammonium phosphate, diammonium phosphate, sodium aluminum sulfate, or mixtures thereof.

11. A filled waffle as recited in claim 1, wherein said outer casing material further includes at least one of an egg, a fat, a milk product, a sweetener, a salt, a fortificant, a colorant, a protein, an emulsifier, a gum, a starch, a coloring agent, a flavoring agent, an antimycotic preservative, or mixtures thereof.

12. A filled waffle as recited in claim 11, wherein said egg comprises at least one of liquid whole egg, dry whole egg, liquid egg whites, dry egg whites, or mixtures thereof.

13. A filled waffle as recited in claim 11, wherein said fat comprises at least one of non-hydrogenated vegetable oil, non-hydrogenated shortening, partially hydrogenated vegetable oil, partially hydrogenated shortening, fully hydrogenated vegetable oil, fully hydrogenated shortening, soybean oil, cottonseed oil, canola oil, peanut oil, safflower oil, sunflower oil, coconut oil, palm oil, palm kernel oil, olive oil, butterfat oil, cocoa butter oil, tallow, lard, corn oil, or mixtures thereof.

14. A filled waffle as recited in claim 11, wherein said milk product comprises at least one of nonfat dry milk, whole milk solids, casein, hydrolyzed milk protein, milk protein isolate, whole milk, partially defatted milk, skim milk, whey, whey products, or mixtures thereof.

15. A filled waffle as recited in claim 11, wherein said sweetener comprises at least one of sucrose, dextrose, fructose, lactose, malt syrup, malt syrup solids, rice syrup solids, rice syrup, invert sugar, malt syrup, malt syrup solids, refiners syrup, corn syrup, corn syrup solids, maltose, high fructose corn syrup, honey, molasses, artificial sweeteners or mixtures thereof.

16. A filled waffle as recited in claim 11, wherein said salt comprises at least one of sodium chloride, potassium chloride, calcium chloride, or mixtures thereof.

17. A filled waffle as recited in claim 11, wherein said fortificant comprises at least one of ascorbic acid, beta carotene, biotin, calcium pantothenate, choline, folic acid, niacin, Vitamin A, Vitamin B₁, Vitamin B₂, Vitamin B₆, Vitamin B₁₂, Vitamin D₂, niacinamide, Vitamin D₃, Vitamin E, Vitamin K, boron, calcium, chromium, copper, iodine, iron, magnesium, molybdenum, nickel, potassium, selenium, vanadium, zinc, calcium citrate, calcium gluconate, calcium lactate, calcium caseinate, calcium chloride, calcium citrate malate, calcium glycerophosphate, calcium hydroxide, calcium malate, calcium stearate, calcium sulfate, or mixtures thereof.

18. A filled waffle as recited in claim 11, wherein said protein comprises at least one of egg albumen, whey protein, soy protein, vital wheat gluten, peanut protein, pea protein, or mixtures thereof.

19. A filled waffle as recited in claim 11, wherein said emulsifier comprises at least one of a mono-glyceride, a di-glyceride, a propylene glycol monoester, a propylene glycol diester, a sodium steroyl lactylate, a lecithin, a polysorbate, a sorbitan monostearate, a glyceryl lacto ester, or mixtures thereof.

20. A filled waffle as recited in claim 11, wherein said gum comprises at least one of pectin, guar, locust bean, tara, gellan, alginate, tragacanth, karaya, Ghatti, agar, gelatin,